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D3212-1

Job Sheet 205100



Part No: D3212-1

Job Qty: 6 pcs

Part Name: Replacement Interior Window For -015 & -025



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/31/19

Job Tracking No:

Due Date: 1/24/20

Created By: Marie Lajeunesse

Type: ~~SOLD~~ *alt*

Description:

Note: DWG REV C IPP Rev: A New Issue 05-11-09 JLM IPP Rev: B Water jet/ ecn798 06-05-08 EC IPP rev.C back on haas 07.04.09 EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	6 pcs		1/24/20	0.17	0.60	Waterjet - Flow		TF/a 20/02/11
110	HAAS 4 Axis - B4B	6 pcs		1/24/20	1.00	1.45	HAAS - 1 - B4B		JRD 20/2/24
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	6 pcs		1/24/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		

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130 QC 8	6 pcs	1/24/20	0.00 0.00	QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	3850 20/12/24
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	7820 20/02/25
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
140 Small Fab - 2 - B4B	6 pcs	1/24/20	0.00 1.42	QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
150 QC 5	6 pcs	1/24/20	0.00 0.00	QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
				Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				Small Fab - 9 - B4B	
				Small Fab - Various 1 - B4B	
150 QC 5	6 pcs	1/24/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	

DAS
58
9-89
2-8-2020

					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	DAS
					QC 5 - 40	MAR 02 2020 40
					QC 5 - 61	9-89
					QC 5 - 81	
160	Packaging 3-1 - Stock - B4B	6 pcs	1/24/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	DAS
					Packaging 3 - 23 - B4B	84
					Packaging 3 - 24 - B4B	9-89
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
170	QC 21 - SA	6 pcs	1/24/20	0.00 0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	DAS
					QC 21 - SA - 53	21
						9-89
	Part Op 100 - 1-Cut blanks. Descriptions: 110 - (HAAS CNC Vertical Machine) 120 - (QC2- Inspect parts off machine FAI/FAIB) 130 - (QC8- Inspect parts - second check) 140 - (Small Fab) 1-Deburr if necessary 2-Install label as per Dwg D3212 3- polish abrasion scratches if necessary.. 4- Wrap in plastic wrap after inspection 150 - (QC5- Inspect part completeness to step on W/O) 160 - (Identify as per dwg & Stock Location: _____) 170 - (QC21- Final Inspection - Work Order Release)					

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D2728-1	Dart Logo Label Small	6 pcs (1 ea)	100-Waterjet - Flow - 1	
MACRLICS.125	1/8" Polycast li Sheet	5.8470 sf (.9745 ea)	140-Small Fab - 2 - B4B	
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	D2728-1	6	2,971	0
140-Small Fab - 2 - B4B	MACRLICS.125	6	1,244	0
Part Specifications				
Specifications could not be found.				

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DART AEROSPACE LTD		Work Order: 205700
Description: Floor Window		Part Number: D3212-1
Inspection Dwg: D3212	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.734	+/-0.005	12.7334	✓		Haas 1	
6.367	+/-0.005	6.3662	✓		"	
0.625	+/-0.005	0.6245	✓		"	
Ø0.156	+0.005/-0.001	0.156	✓		Precision Pin	
R0.25	+/-0.030	0.25	✓		Radius Gauge	
8.150	+/-0.005	8.1483	✓		Haas 1	
3.750	+/-0.005	3.7503	✓		"	
0.313	+/-0.010	0.312	✓		"	
15.14	+/-0.030	15.148	✓		Vernier	
12.520	+/-0.005	12.5183	✓		Haas 1	
6.260	+/-0.005	6.2594	✓		"	
1.312	+/-0.005	1.3116	✓		"	
0.313	+/-0.010	0.312	✓		"	
3.750	+/-0.005	3.7503	✓		"	
8.150	+/-0.005	8.1483	✓		"	
8.462	+/-0.005	8.4633	✓		"	
9.09	+/-0.030	9.099	✓		Vernier	

Measured by: JRD	Audited by: an	Preliminary Approval:
Date: 20/12/24	Date: 20/02/25	Date:

Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue P/O D350-567-015/-025/-031	KJ/RF	
B	07.05.28	Dimensions updated per Dwg Rev. B	KJ/JLM	
C	12.02.01	Dwg Rev updated	KJ	

Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only



Job: _____ Part No. _____		DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality		DEPARTMENT/PROCESS	
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition			
Root Cause ☐ Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled Other/Details: _____		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up			
		Completed By			
		Lead hand / Supervisor			
		QC / QA Coordinator			